

Date: Tuesday, 11/21/2006 11:36:13 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 29578  
Estimate Number : 12481  
P.O. Number : N/A  
This Issue : 11/21/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 29543  
Written By : [Signature]  
Checked & Approved By : [Signature] 06 11 21  
Comment : Est Rev A New Issue 06-06-28 JLM

Drawing Name : SPACER  
Part Number : D35201  
Drawing Number : D3520 ~~PRELIMINARY~~  
Project Number : N/A  
Drawing Revision : ~~PREL~~  
Material : N/A  
Due Date : 11/28/2006  
Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X01000	6061-T6 Bar .50" x 1.0"
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Comment: Qty.: 0.1218 f(s)/Unit Total : 2.4360 f(s)  
6061-T6 Bar .50" x 1.0"  
(M6061T6B0500X1000)  
Batch: M18133

J.F. 06/11/29

(21)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut Blanks 1.400" long

J.F. 06/11/29

(21)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA646 Rev: AA & Dwg D3520 Rev: A

2-Deburr per dwg D3520

J.L 06/11/30 (21)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06/11/30 (21)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 06/11/30 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

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Drawing Name: SPACER

Job Number: 29578

Part Number: D35201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*a.m 06/11/30 (21X)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*fc 06 12 01 (21)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*fc 4/12/07 21*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*fc 4/12/07 (21)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/12/07 (21)*

Job Completion



*C Loc 112104*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

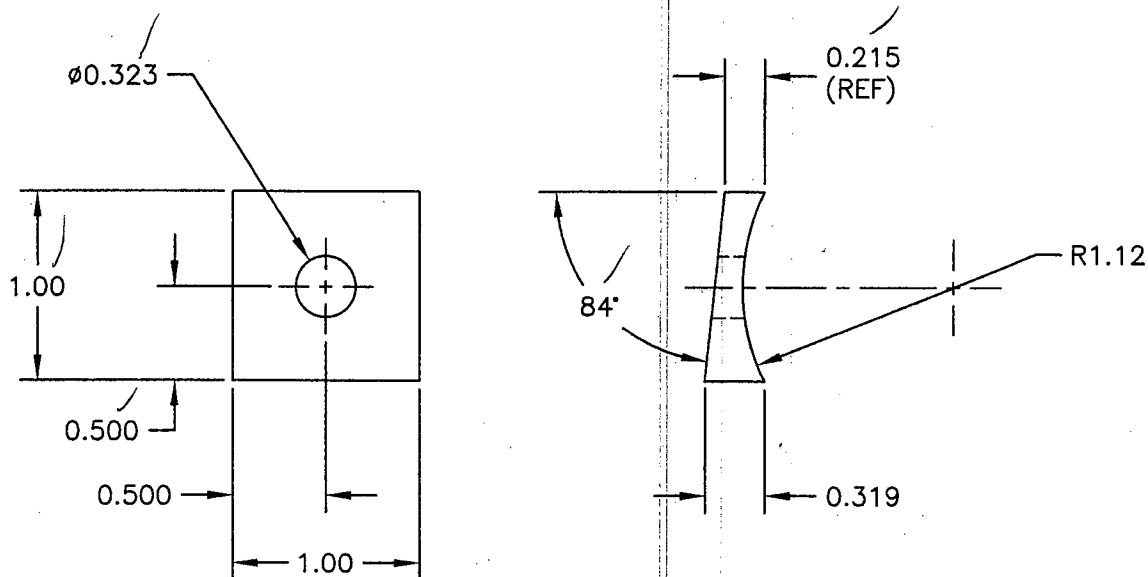
NOTE: Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3520	REV. A SHEET 1 OF 1
DATE 06.06.28		TITLE (A119 BASKET) SPACER	SCALE 1:1
A	06.06.28	NEW ISSUE	

RELEASED

06.11.17



### D3520-1 SPACER

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART MATERIAL SPEC M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 29578

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